Work Orde September-23-13	er ID 107411 3 11:50:19 AM			*107411*									=
Revision ID:	D2161-205			Accept	*N900)* s	etup St	art op	14.21				
Start Date: Required Date:		Qty: 2.00 Qty: 2.00	*2* *2*		Cust Item I Customer:				-r	"IV.	、 フ		
Reference:	Process Plan: QC:	V	Date:	Tooling: SPC (Y/N):		ate:		R		art top	*NI *NI	₹1* ₹2*	
Sequence ID/ Work Center II	Operat D Descrij			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		eject umber	Insp. Stamp	
Draw Nbr	Revision Nb	r											
D2161	Rev B2												
*100 *100* Large Fab Large Fab	Large Fa	Memo 1-Assemb	ole on Jig DT8065 as per Dw s per Dwg D2161 Identify as					4		2/)-C	<u>/3-10</u> -1	7
*110 *110* QC Quality Control	QC9- In	spect visual po	er QSI004- Fusion Welds	0.00				Ð		2/	DAS 9 9-89		ل
120 *120* QC	QC5- In		npleteness to step on W/O	0.00					D 1	<u> </u>	D-23	DAS 9 9-89	
QΨ		Memo		0.00								2-09	

Quality Control

DQA:	Date:	
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WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Water Jet Engineering Skid-tube Crosstube Rework Prod. Eng. Coor. Machining Small Fab Quality Part No. Scrap Thermoforming Finishing Rec/Store/Packaging Other Use-as-is Work Order Update Composite Supplier Large Fab NCR No. Description of work order update Action Sign & Initial Root Date Step Qtv or Non-conformance Chief Eng Description Date Verification QC Inspector Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Bend Grain Ovalized Pressure/Forced Bending BOM/Route Centre Not Concentric to O/S Hardware Over/Under tolerance Temperature/Cure Broken/Damaged Cracks Inspection Incomplete Part Incorrect Weld Crushed/Crimped Wrong Stock Pulled Burrs Instructions Incomplete/Unclear Part Lost/Missing Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other **Drill Holes** Offset Ripples in Bend **Torque Waves in Extrusion** Drawing Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 107411 Page 2 September-23-13 11:50:19 AM *N900040100* Accept Setup Start Item ID: D2161-205 **Revision ID:** Mirror Bracket, 205 Item Name: Start Qty: 2.00 **Start Date:** 9/23/13 **Cust Item ID: Req'd Qty:** 2.00 Required Date: 9/23/13 **Customer:** Reference: Start Run Process Plan: Date: Approvals: Tooling: Date: Stop SPC (Y/N): Date: Date: Reject Sequence ID/ Set Up/ Tool ID Tool # Plan Accept Reject Insp. Operation Qty Number Stamp Code Qty Work Center ID Description **Run Hours** Black Sandtex(Ref)4.3.5.7) per QSI005 4.3 130 0.00 DAS *130* 0.00 Powdercoat Powder Coating DAS 27 QC3- Inspect Part Finish 0.00 140 9-89 *110* QC Memo Quality Control DAS Identify as per dwg & Stock Location: 150 0.00

150

Packaging

Packaging

0.00

13/1/25 (4)

TMENT/PROCESS									
sed: Date:									
QA: Date:									
QA: Date:									

WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Y	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE															
					•				-		QA Closed:	Dat	e:			
Work Orde	r:					DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part N	Part No.					Rework Scrap Use-as-is	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing				Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other			
NCR N	lo					Work Order Update	L		Large Fab	Composite	Supplier					
Root	T				Descri	ption of work order update	Ti	nitial	Ac	tion	Sign &					
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification		QC Inspector		
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Other	_															
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-	—₁	Bending			o/s	Bend BOM (Bouts	\vdash	Grain		<u> </u>	i			Pressure/Forced		
}	-	Centre No Cracks	ot Concer	ntric to	^{∪/s}	BOM/Route	\vdash	Hardwa		<u> </u>	Over/Under Part Incorred	ŀ	_	Temperature/Cure Weld		
1 }	_	Crushed/	Crimonad		-	Broken/Damaged Burrs	\vdash	4 `	ion Incomplete tions Incomplete/	Unclose	Part Lost/Mi			weiu Wrong Stock Pulled		
	\dashv	Cuffs	Crimpeu		-	Contamination		Mainte	•	- Criclear	Part Moved	22111B [wrong Stock Pulled		
1	\dashv	Julis Heat Trea	.+		-	Countersink	-	Mislabe		-	Positioned V	Vrong				
] 	-	nspection		Tube	<u> </u>	Cut Too Short	\vdash	Misread			Power Loss/	·	7	Other		
	_	Ripples in		, une	\vdash	Drill Holes	\vdash	Offset	4	<u>L</u>	J. Ower Loss/	Juige		Other .		
	-			xtrusio	<u>,</u>	Drawing	\vdash	-1	Calibration							
	Torque Waves in Extrusion Drawing Turning Sequence Finish						\vdash	4	Sequence							
1 1	-1	Wave/Twist in Tube						Outside								

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Work Ord September-23-1				*107		Page 3						
Item ID: Revision ID: Item Name:	D2161-205 Mirror Bracke	et, 205		Accept	*N900	040	100	* Setup	Start Stop	*N:		
Start Date: Required Date Reference:	9/23/13 :: 9/23/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:						
Approvals:	Process Plan:QC:		Date:	Tooling: SPC (Y/N):	Date:			Run	*NR1* *NR2*			
Sequence ID/ Work Center 1 160 *160* QC Quality Control	ID.	Operation Description QC21- Final Inspection Memo	- Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Ro	ry W 13	Reject Number	Insp. Stamp -29	- 23

							•				DQA:	Date			
NCR: Y	⁄es	/ No				WORK ORDER NON-O	COI	NFORM	ANCE / UP	DATE					
										QA Closed:	Date	:			
Work Orde	or.					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No						Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab Use-as-is Thermoforming Finishing				4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root	П				Descri	ption of work order update		Initial	Act	tion	Sign &				
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector		
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Equip/Tooling															
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Training		:					1					-			
Unapproved			i												
						F	AUL	T CATE	GORY						
Landi	ng G	ear				General	_	-			-		_		
		Bending				Bend	L	Grain			Ovalized		Pressure/Forced		
	Ш	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure		
		Cracks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorred	ct	Weld		
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
		Cuffs				Contamination		Mainte	nance		Part Moved				
		Heat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	_		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other		
		Ripples in	Bend			Drill Holes		Offset				_			

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

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September-23-13 11:50:19 AM

Work Order ID:

107411

Parent Item:

D2161-205

Parent Item Name:

Mirror Bracket, 205

Start Date: 9/23/13

Required Date: 9/23/13

Start Qty: 2.00

Required Qty: 2.00

Comments:	IPP Rev:A New	Issue 05-11-01	JLM										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2013-1 Mirror Bracket LH, 205		Manufactured	No			100	Each	4.0000	1	和义	me	13.	10.17
Willion Blacket Elli, 203				<u>Location</u>		Loc Oty	Lo	c Code					
				WA001	018	4 2			15	<u> </u>			
				/984 /998		1			<u>+ </u>	<u> </u>			
D2013-2 Mirror Bracket RH, 205		Manufactured	No		==	100	Each	4.0000	1	#)7 ²	20-6		3.10.1=
				Location		Loc Qty	<u>Lo</u>	oc Code					
				WA001 	19]	4 2 1 1			\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	Z			
D2037-101 Arm		Manufactured	No		-	100	Each	11.0000	1		ml	/	13:10:1
				Location		Loc Qty	<u>L</u> c	oc Code					
				WA001 2102 2102		11 1 10			x x	5		,	

											DQA:	Date:			
NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:															
						DISPOSITION	DISPOSITION					/PROCESS			
Work Order:						Rework		Skid-tube	Crosstube	7	Water Jet	Engineering			
Part No.						Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
1 4101	10.					Use-as-is	1 1		noforming	Finishing	⊣	re/Packaging	Other		
NCR I	No.					Work Order Update	1		Large Fab	Composite	1	Supplier			
	•						_		·		-	•	·		
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &				
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector		
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Other	Н														
Process	\vdash														
Supplier	\vdash		1												
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Unapproved			<u> </u>				A I II	T CATE	COPY	-	l	<u> </u>			
Landi	ina (Gear				General	AUI	LICAIL	GORT						
Larro	, E	Bending				Bend	Г	Grain		Г	Ovalized	<u></u>	Pressure/Forced		
	\vdash	Centre No	ot Concei	ntric to	o/s	BOM/Route	\vdash	Hardwa	ire		Over/Under	tolerance	Temperature/Cure		
	\vdash	Cracks			·	Broken/Damaged	\vdash	4	ion Incomplete		Part Incorre	· · ·	Weld		
Crushed/Crimped						Burrs		4 .	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled		
	Cuffs					Contamination		Mainte	enance		Part Moved				
	Heat Treat					Countersink Mislabeled						Positioned Wrong			
		Inspectio	n Strip in	Tube								/Surge	Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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